

010206



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C45-C

Job Sheet 195332



Part No: C45-C

Job Qty: 1 pcs

Part Name: Single Cage Assembly (C45 & C60 Hook)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/17/19

Job Tracking No:

Due Date: 5/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-C rev.E IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP IPP REV:B 19.05.02 AS PER DWG REV.E DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - Issue SN	1 pcs	5/27/19		0.00	1.00	External Load - 1		AP 2019/06/05
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	5/27/19		0.00	0.50	External Load - 1 - B4B		AP 2019/06/05 Noble 2019/6/5
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	5/27/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Packaging 3-1 - Stock - B4B	1 pcs	5/27/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S187966



Part: C45 - C

Job No: 195332

Serial No/Batch: S187966

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 06/05/19

DAS

30

9-89

JUN 6 2019

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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	5/27/19	0.00 0.00	QC 21 - SA - 21	DAS	JUN 06 2019
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	9-89	

Part Op 100 - Issue S/N

Descriptions: 110 - (Small Fab)ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT WILL NOT FALL OUT***

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____)

160 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN12H32	Bolt	1 pcs (1 ea)	100-External Load - Issue SN	5159804
AN310-12	Castellated Nut	1 pcs (1 ea)	110-External Load - 2 - B4B	5004855
AN8-23A	Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	5085037
C45-15-10	Ford Bumper	1 pcs (1 ea)	110-External Load - 2 - B4B	5177794
C45-15-11	Nut, Cage Bumper	1 Ea (1 ea)	110-External Load - 2 - B4B	5036837
C45-15-6	Bushing, Lifting	1 pcs (1 ea)	110-External Load - 2 - B4B	5180462
C45-15-7	Washer, Lifting Bolt	4 pcs (4 ea)	110-External Load - 2 - B4B	5175984
C45-18-7	Shim	4 Ea (4 ea)	110-External Load - 2 - B4B	5184166
C45-19C	Weldment	1 pcs (1 ea)	110-External Load - 2 - B4B	145343 S186013
MS21044N8	Nut, Self-Lock .500-20,UNJF-3B	2 Ea (2 ea)	110-External Load - 2 - B4B	51475053
MS24665-363	Cotter Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5092509-1
NAS1149C0663R	Washer	1 Ea (1 ea)	110-External Load - 2 - B4B	5076016-1
NAS1149F0832P	Washer	4 Ea (4 ea)	110-External Load - 2 - B4B	5076018-4

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - Issue SN 110-External Load - 2 - B4B	AN12H32	1	44	0
	AN310-12	1	26	0
	AN8-23A	2	68	0
	C45-15-10	1	7	0
	C45-15-11	1	78	0
	C45-15-6	1	27	0
	C45-15-7	4	61	0
	C45-18-7	4	18	0
	C45-19C	1	2	0
	MS21044N8	2	37	0
	MS24665-363	1	79	0
	NAS1149C0663R	1	495	0
	NAS1149F0832P	4	235	0

Part Specifications

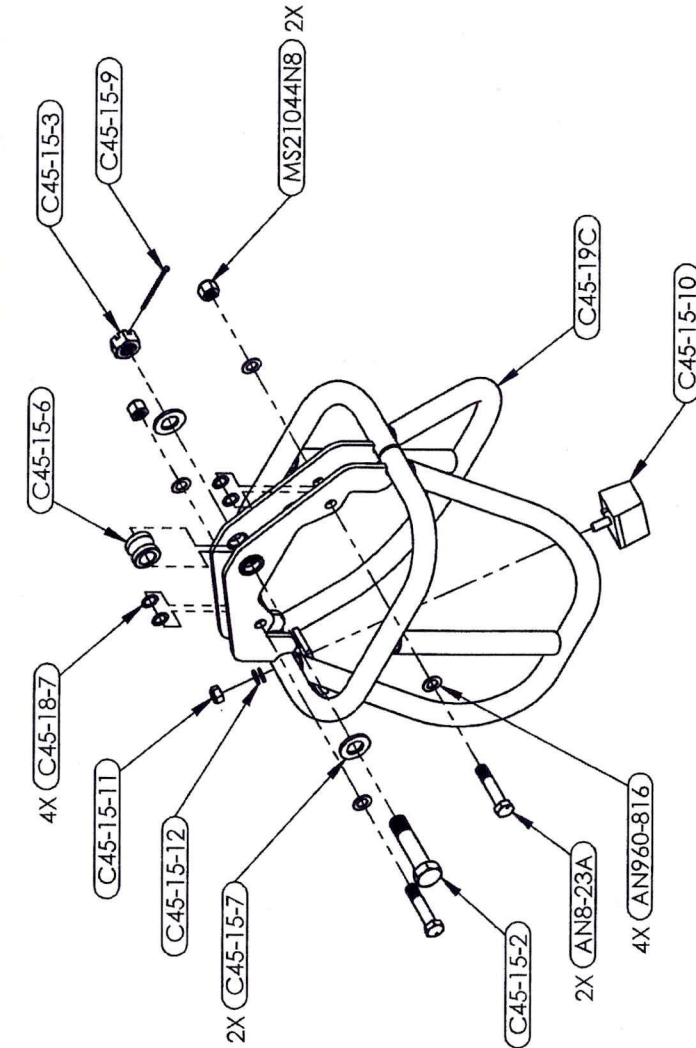
Specifications could not be found.

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		AS DRAWN BY APICAL	11/6/2012	JAG	
4	15-0180	UPDATED TO NEW DRAFTING STANDARDS. CHD P/N WAS C45-15-8 IS AN960-816, C45-15-4 DELETED, REPLACED WITH AN8-23A, C45-15-5 DELETED, REPLACED WITH MS21044N8, C45-18-7 ADDED TO BOM QTY 4.	7/22/2015	DPD	JAG
E	19-660	Replace B/O info for C45-15-2, C45-15-3 and C45-15-9, C45-15-12	04/12/2019	ML	



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195332 ML
19-05-17



C45 CAGE

ASSY QTY	ASSY B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
		C45-19C	1	WELDMENT		
		C45-15-2	1	LIFTING BOLT	STEEL	AN12H32
	B/O	C45-15-3	1	CASTLE NUT	STEEL	AN310-12
	B/O	C45-15-7	2	LIFTING BOLT WASHER	STEEL	3/4 (MCMASTER-CARR #98023A036)
	B/O	C45-15-9	1	COTTER PIN	S.S	MS24665-363
		C45-15-10	1	FORD BUMPER		(#E31Z-4730-A) MODIFIED
	B/O	C45-15-11	1	CAGE BUMPER NUT	STEEL	M10, CLASS 8 (MCMASTER-CARR #90576A118)
	B/O	C45-15-12	1	CAGE BUMPER WASHER	STEEL	NAS1149C0663R
		C45-15-6	1	LIFTING BUSHING	4140/4142	
	B/O	C45-18-7	4	SHIM	STEEL	.025 X Ø.511 I.D. (MCMASTER-CARR #3088A412)
	B/O	AN8-23A	2	BOLT	STEEL	1/2-20 X 1.47
	B/O	AN960-816	4	LIFTING BOLT WASHER	STEEL	AN960-816 (NAS1149F0863P)
	B/O	MS21044N8	2	NUT	STEEL	1/2-20

DRAWN BY: APICAL
APPROVED: ML
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ± 1/8
DECIMALS ± .01
ANGLES ± .5°
1. BREAK ALL SHARP EDGES .015 x 45°
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

USED ON MODEL

SCALE 1:8 DATE 4/12/2019 SHEET 1 OF 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					